

Work Order ID 109951

April-11-14 9:21:06 AM

Repeat

109951

Page 1

Item ID: D3512-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 12/09/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 12/23/13 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: *h* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3512	D

120 0.00

120 Large Fab

Large Fab Memo 0.00

Large Fab 1- Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

A/R 2059b Hardcoat Rod

2- Weld D3512-3 spacer to D3512-1 as per dwg

A/R S.S. Rod

130 QC9- Inspect visual per QSI004- Fusion Welds 0.00

130

QC Memo 0.00

Quality Control

Correct
h
Mo-13

Picklist Print

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April-11-14 9:21:05 AM

Work Order ID: 109951

109951

Parent Item: D3512-041

D3512-041

Parent Item Name: Wearplate Assembly

Start Date: 12/09/13

Required Date: 12/23/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP
REV:B 13.12.11 ECN13-619/REV.D DWG DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3512-3		Manufactured	No				Each	16.0000		8			
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D3512-3

Spacer

Location	Loc Qty	Loc Code
WA001	16	

113028

16

M304S18GA

Purchased

No

100

sf

409.9600

4

M304S18GA

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT019	397.96	

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

39.75

M128254

113.96

M128435

187.25

MAT020

12

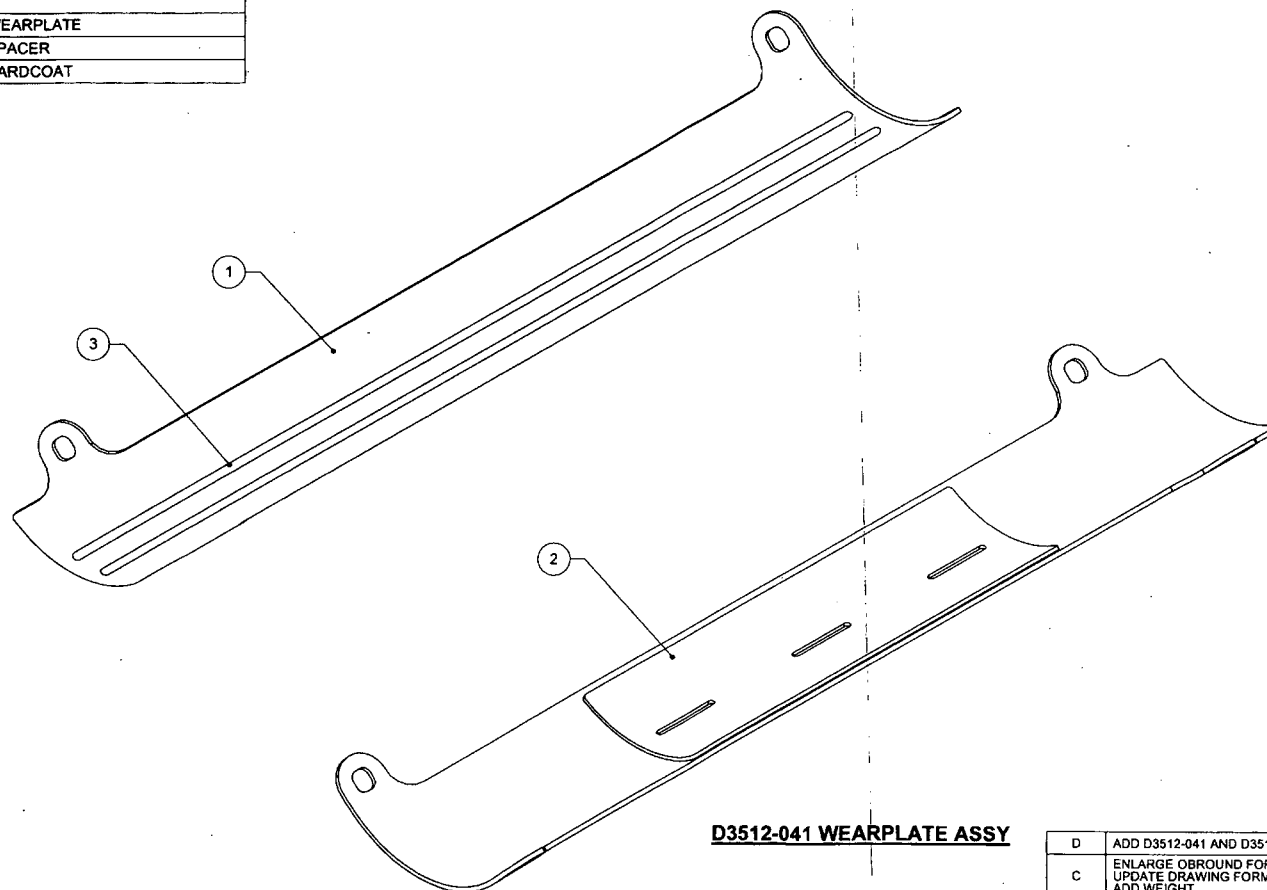
124029

2

M126098

10

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT

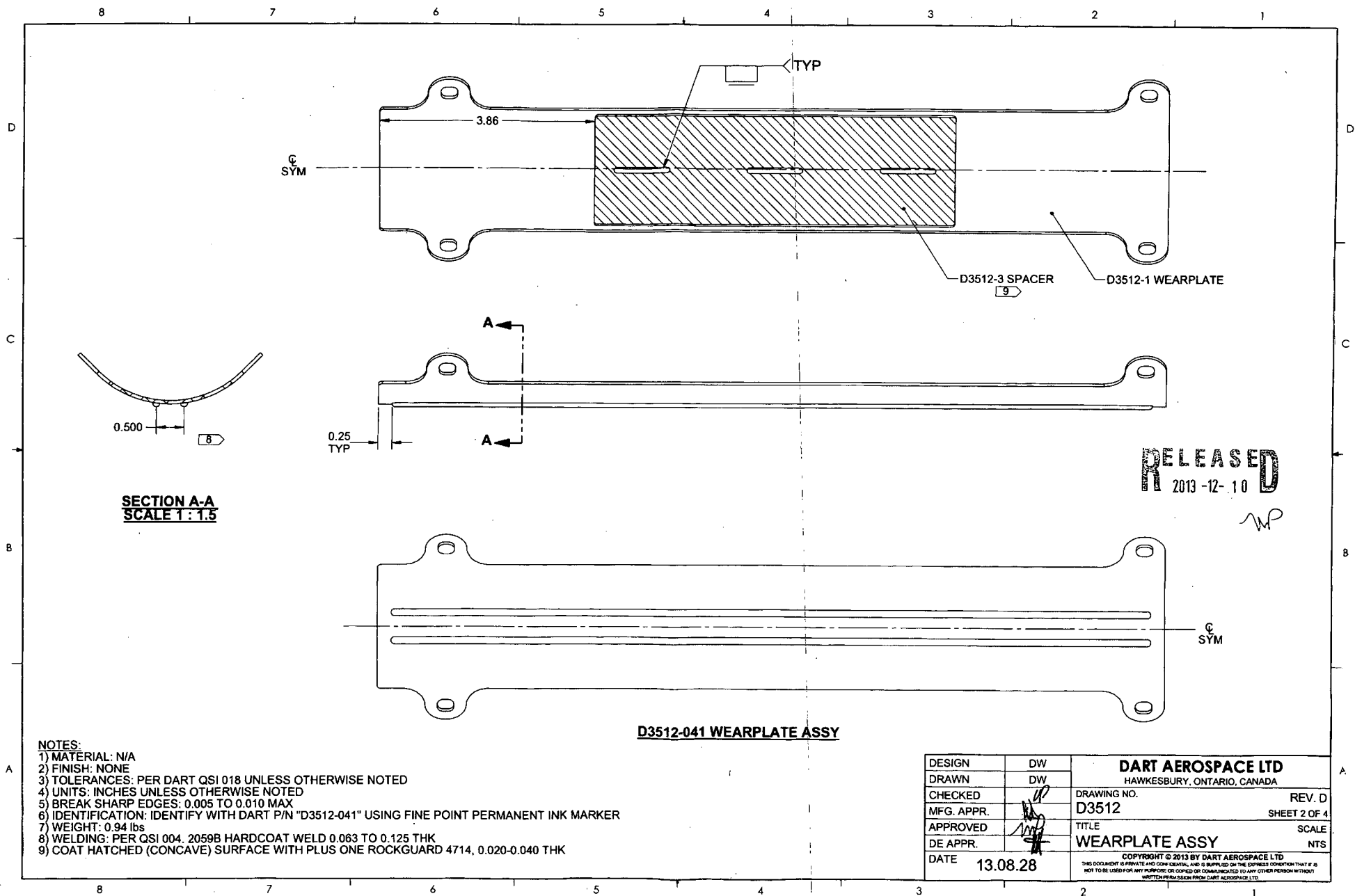


D3512-041 WEARPLATE ASSY

109951MCS
14-04-11

RELEASED
2013-12-10
WP

D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOURD FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

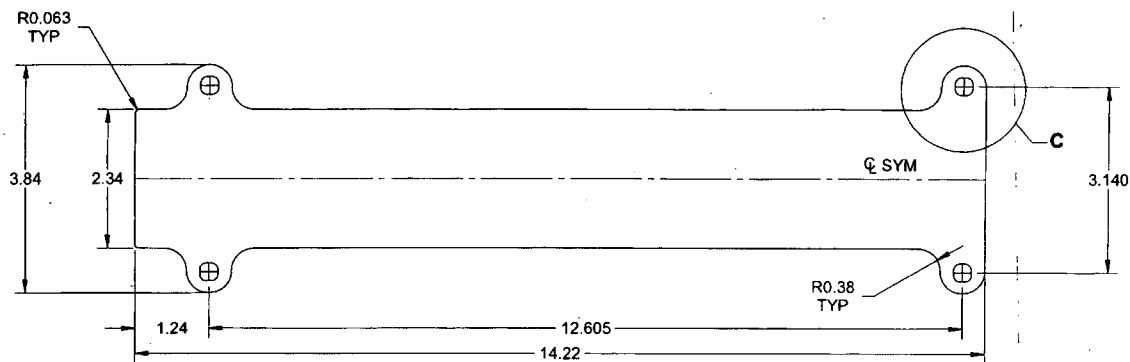


8 7 6 5 4 3 2 1

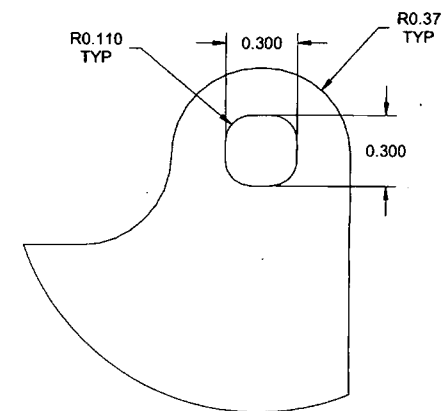
D

C

B



D3512-1F



DETAIL C
SCALE 2X

RELEASED
2013-12-10
WP

NOTES:

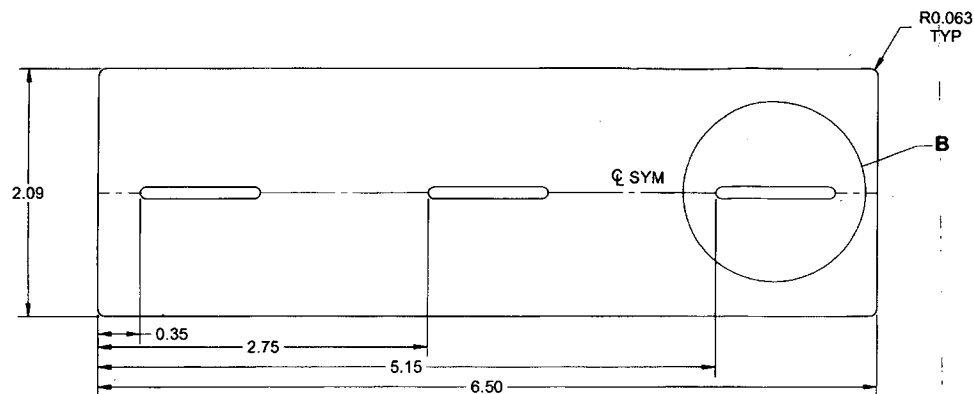
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AW	DRAWING NO.	REV. D
MFG. APPR.	AW	D3512	SHEET 3 OF 4
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	WEARPLATE ASSY	NTS
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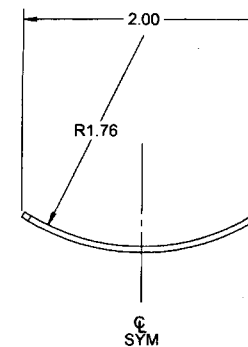
8 7 6 5 4 3 2 1

A

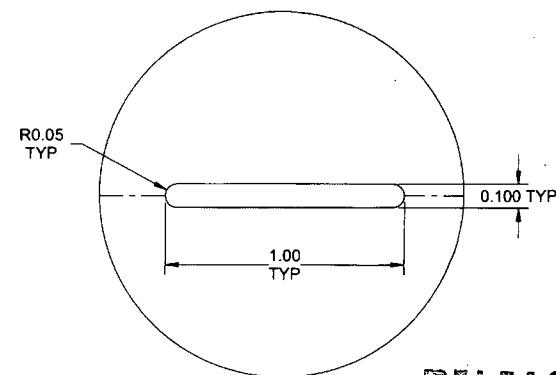
A



D3512-3F FLAT PATTERN



D3512-3 SPACER
MAKE FROM D3512-3F



DETAIL B
SCALE 2X

RELEASED
2013-12-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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